

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029946**Date Inspected:** 23-Aug-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Fred Michels**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG & Bikepath**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

Underneath the bike path at panel point PP121 after the completion of CJP welding and the grinding on the weld splice butt joint for the traveler inner rail, this QA performed a visual inspection on the completed weld joints of top flange, bottom flange and the web. During the visual verification of the welded joint, this QA noted an out of straightness of the welded butt joint of approximately 7mm. This was brought to the attention of ABF Field Engineer Brett Clark who also informed Caltrans Engineer Tuc Tran. Mr. Tran sent another Caltrans Engineer Mr. Thangh Le who came and assessed the situation. After learning of all the facts, Mr. Lee informed ABF Engineer Brett Clark to put the out of straightness issue to a Request for Information (RFI) as a "Fit for Purpose" recommendation since the affected area is only on top flange. ABF Engineer Brett Clark agreed to the proposal and said will bring it to the attention of ABF.

Later in the afternoon, Mr. Tuc Tran called this QA and asking about the condition of the splice butt joint. This QA informed Mr. Tran that the weld joint looks good and passed the MT/UT except that there was a distortion during welding that caused the out of straightness. Mr. Tran informed this QA that he has no problem with the out of straightness as long as the weld splice joint was deemed acceptable. He then added that the RFI is no longer necessary and that he is accepting the out of straightness as is.

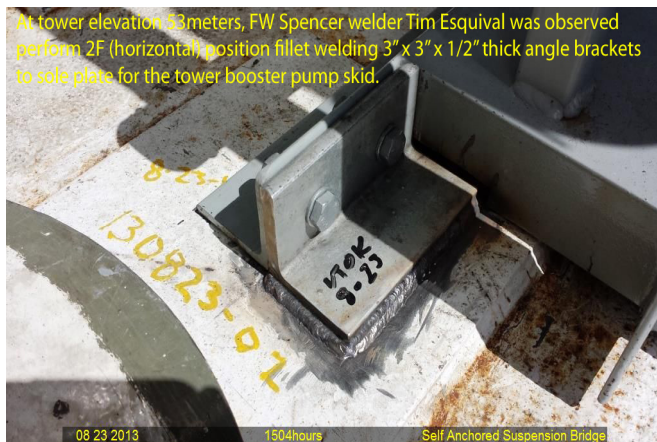
FW Spencer:

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The QAI observe the ongoing installation, field fit-up and tack welding of the Tower Booster Pump Skid welding. The angle clip 3" x 3" x 1/2" thick 6" long was welded to the previously welded sole plate on top of the tower plate. The FW Spencer welder Tim Esquivel was observed fillet welding the four clips utilizing the Shielded Metal Arc Welding (SMAW) process using the 1/8" diameter E7018H4R electrode as per the Welding Procedure Specification (WPS) identified as Fillet Murex. The QC inspection was performed by Fred Michels during the tack welding, the fillet welding and the monitoring of the welding parameters. The tack welding and fillet welding of the four clips to the sole plate was completed during the shift.

At IERBYS Building, this QA performed material verification of the assembly of three light pole anchors. The anchor assemblies consist of five 1 1/2", 1 3/4" and 2" diameter rods with nuts and washers on each end that were assembled on the top and bottom templates. The three various sizes assemblies were all in good condition and deemed in conformance to the project requirements.



Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas 916-764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Reyes, Danny

QA Reviewer